

# Work Order ID 85309

**\*85309\***

June-05-12 3:34:29 PM

Item ID: D2432

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 206 (24") Bearpaw

Start Date: 05/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/06/05*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

**\*120\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File ✓

*4 0*

*Jun 12-6-24*

130

0.00

**\*130\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2432 Identify as D2432F  
3-Deburr

*4 12-07-04 (x4)*

140

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*4 12 07 04 (x4)*

WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 85309

**\*85309\***

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Revision ID:

Item Name: 206 (24") Bearpaw

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Start Date: 05/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

Quality Control

*OK 12/07/04*

*4*

151

Identify as per dwg & Stock Location:

0.00

**\*151\***

Packaging

Memo

0.00

Packaging

*PPP 85303*

*Res 12/7/6 (4)*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*OK 12/7/9*

*MF 12-07-06*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-05-12 3:34:33 PM

Page 1

Work Order ID: 85309

\*85309\*

Parent Item: D2432

\*D2432\*

Parent Item Name: 206 (24") Bearpaw

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	131.2100	3.7	14.8			

\*MUHMWB10\*

UHMW 1" Black

\*\*

Jun 12-6-24

### Location

### Loc Qty

### Loc Code

MAT018

108.1

120972

1

121346

27.1

121954

80

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

8.80999474

121954

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	85309
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.080	✓		vern	IT-4
B	5.500	+/-0.030	5.501	✓		vern	
C	0.200	+/-0.030	.212	✓		depth gauge	IT-6
D	0.25 x 45°	+/-0.030	.250	✓		vern	IT-4
E	R0.250	+/-0.030	.250	✓		rad gauge	
F	0.250	+/-0.010	.244	✓		vern	IT-4
G	0.625	+/-0.030	.620	✓		"	
H	0.375	+/-0.010	.378	✓		"	
I	0.950	+0.030/0.010	.964	✓		"	
J	19.000	+/-0.030	19.000	✓		Tape	IT-10
K	3.14	+/-0.030	3.128	✓		vern	IT-4
L	3.28	+/-0.030	3.300	✓		"	
M	Ø0.260	+0.005/-0.000	.260	✓		"	
N	Ø0.93	+/-0.030	.926	✓		"	
O	0.30	+0.030/-0.000	.312	✓		depth gauge	IT-6
P	23.750	+/-0.030	23.750	✓		Tape	IT-10
Q	7.375	+/-0.030	7.375	✓		"	
R	4.250	+/-0.010	4.250	✓		"	
S	2.000	+/-0.030	2.000	✓		vern	IT-4
T	9.000	+/-0.010	9.000	✓		Tape	IT-10
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	.380	✓		vern	IT-10

Measured by:	CT	Audited by:	CT	Prototype Approval:	N/A
Date:	12/07/04	Date:	12/07/04	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

**Dart Aerospace Ltd**

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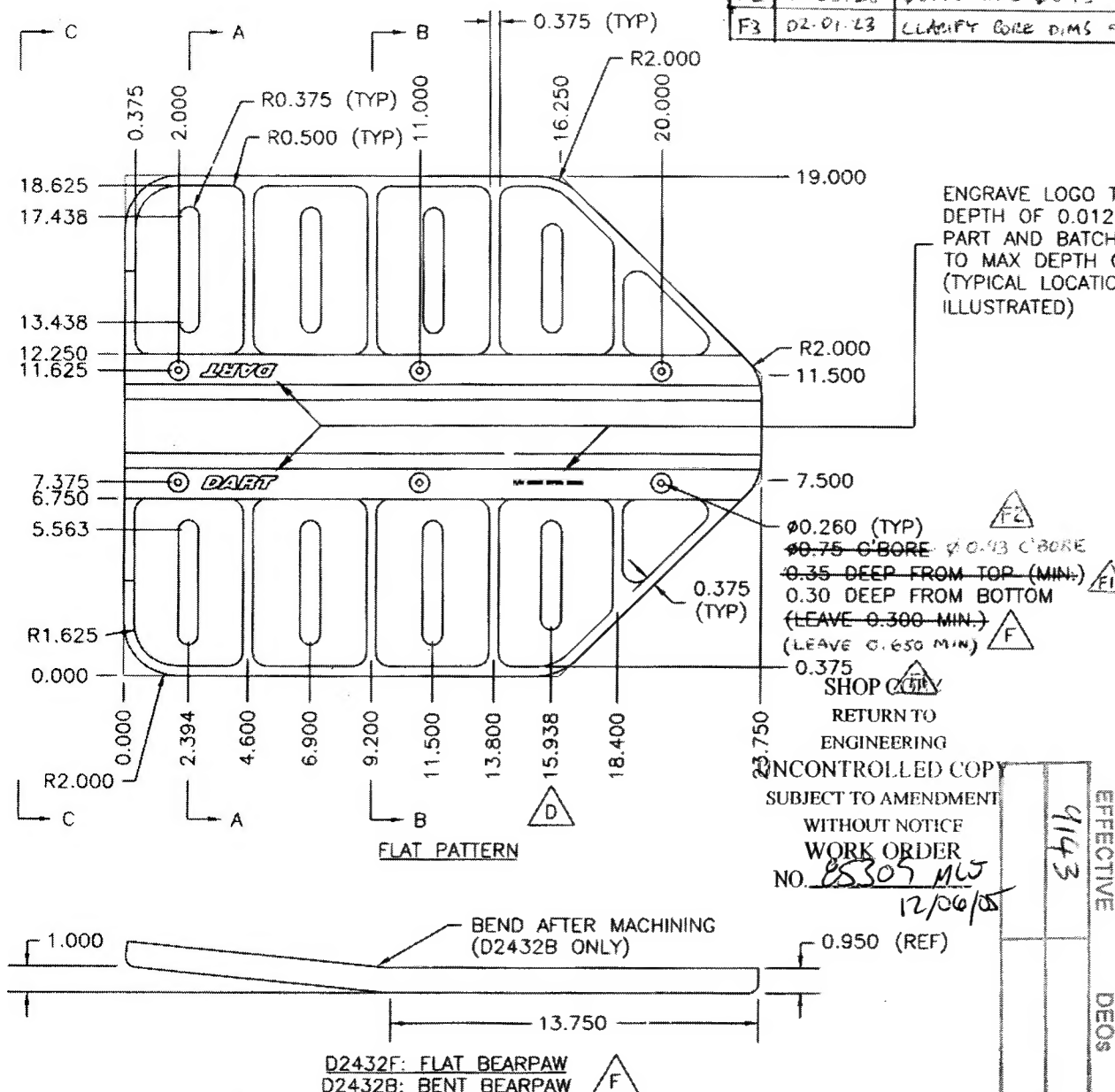
F1	99.03.03	ADD DEC 9143
F2	01.03.28	<del>Ø0.75 WAS Ø0.75</del> RF
F3	02-01-23	CLARIFY BORE DIMS OF RF

RELEASED  
98.06.17 KE



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED MM	APPROVED MM	DRAWING NO. D2432
DATE 98.05.12	TITLE BEARPAW	REV. F SHEET 1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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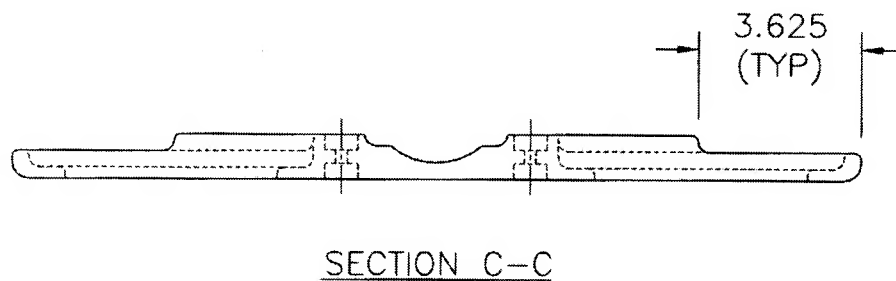
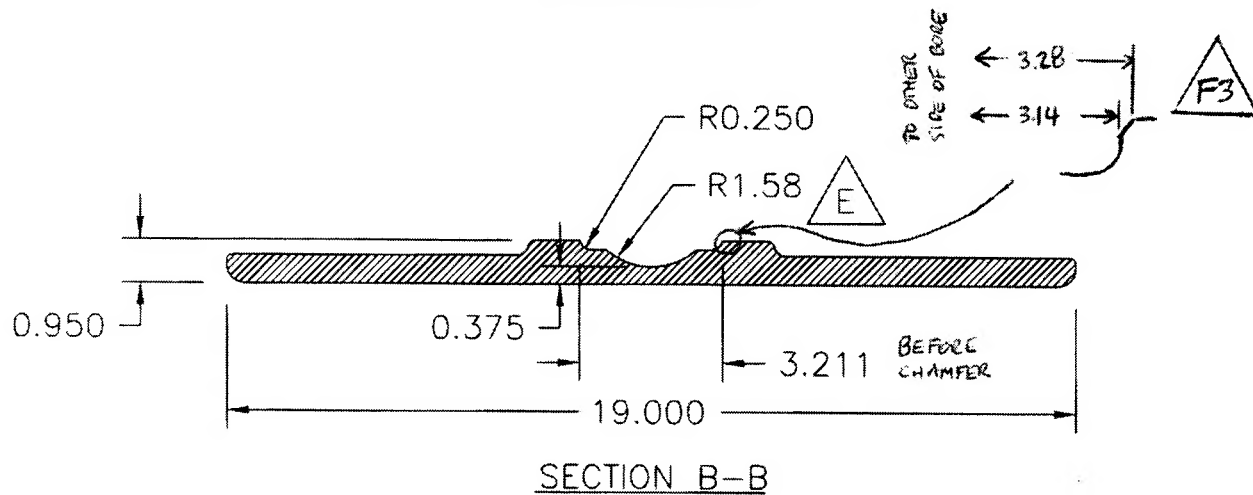
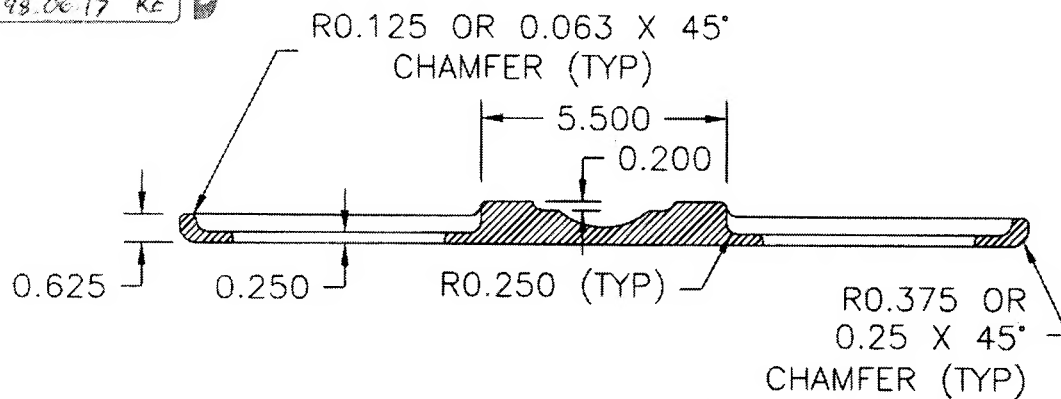
**NOTE:** Date & initial all entries

**DART**



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



85309

**Dart Aerospace Ltd**

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